

Work Order ID 56777

March 10, 2010 7:16:57 AM



Page 1

Item ID: D3815-2

Accept



Setup Start



Revision ID:

Item Name: Angle

Stop



Start Date: 3/10/10

Start Qty: 12.00



Cust Item ID:

Required Date: 3/12/10

Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3815

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3815 ☐ Dwg Rev: A ☐ Prog Rev: A

☐

****grain direction along 4.30" ****☐ 2-Deburr if necessary

IB 10-3-10

2024 . 063

15

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

IB 10-3-10

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Swobzh

45

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56777

March 10, 2010 7:16:57 AM



Page 2

Item ID: D3815-2

Revision ID:

Item Name: Angle

Start Date: 3/10/10

Start Qty: 12.00

Required Date: 3/12/10

Req'd Qty: 12.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

1- deburr if necessary
D3815

0.00

0.00

□2- Bend as per Dwg

8/10/03/12

15

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/10/03/12

+10

-2

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

PR 10-3-15

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56777

March 10, 2010 7:16:58 AM



Page 3

Item ID: D3815-2

Revision ID:

Item Name: Angle

Start Date: 3/10/10 Start Qty: 12.00

Required Date: 3/12/10 Req'd Qty: 12.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

EP 10/03/15 (15)

170



Packaging

Packaging

Identify as per dwg & Stock Location: G-A

0.00

Memo

0.00

EP 10/03/15 (15)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/16 J

Pd 10-3-14 (15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 10, 2010 7:16:56 AM

Page 1

Work Order ID: 56777



Parent Item: D3815-2



Parent Item Name: Angle



Comments: IPP Rev:A 08-09-18 new issue DD verified by:EC

Start Date: 3/10/10

Required Date: 3/12/10

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.063  2024-T3 .063 sheet		Purchased	No			100	sf	133.8802	5.8459	7.4		
											1B10-3-10	

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

133.8801505

105916

1.09

110980

5.4854

111787

0.00475051

113866

69.3

113867

56

19059

2

113867

15

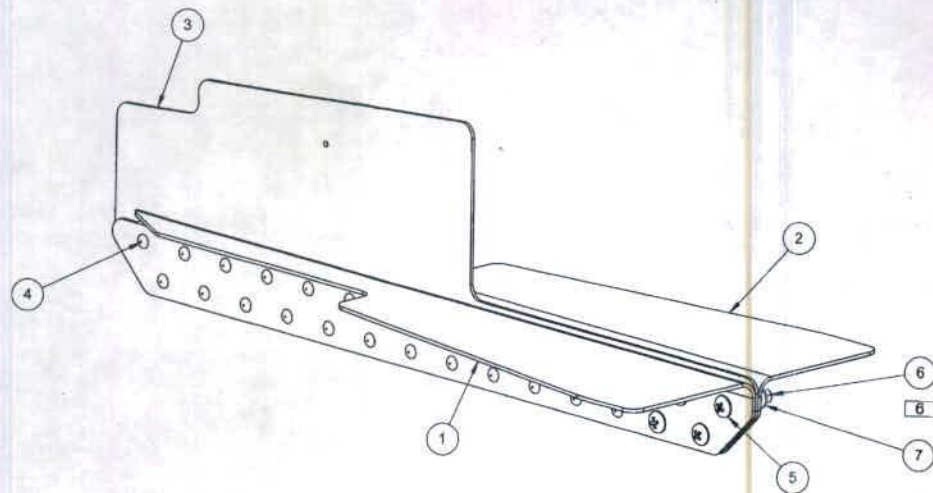
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ITEM NO.	PART NUMBER	DESCRIPTION	QTY. -041
1	D3815-1	ANGLE	1
2	D3815-2	ANGLE	1
3	D3815-3	WEB	1
4	MS20470AD4-6	RIVET	25
5	AN526C832R14	SCREW	4
6	MS21042L08	NUT	4
7	NAS1149DN832J	WASHER	4

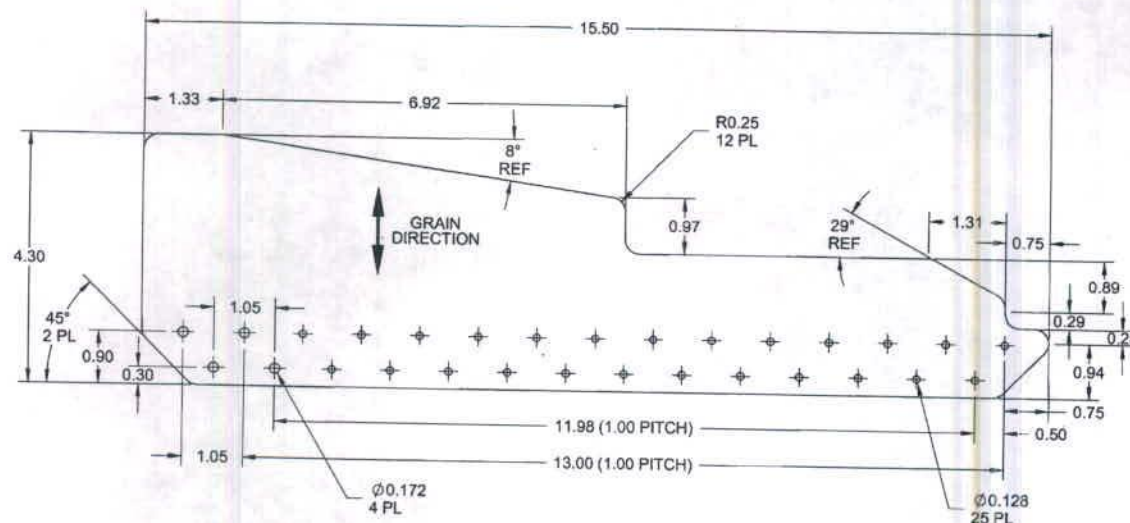
D3815-041 WEB ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N D3815-041 USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.88 lbs
- 6) INSTALL LOOSE (4 PLACES) AFTER POWDER COAT

RELEASED
09/09/12

A		NEW ISSUE		BY		DATE	
REV.		DESCRIPTION					
DESIGN		DART AEROSPACE LTD					
DRAWN		HAWKESBURY, ONTARIO, CANADA					
CHECKED		DRAWING NO.		REV. A			
MFG. APPR.		D3815		SHEET 1 OF 5			
APPROVED		TITLE		SCALE			
DE APPR.		WEB		NTS			
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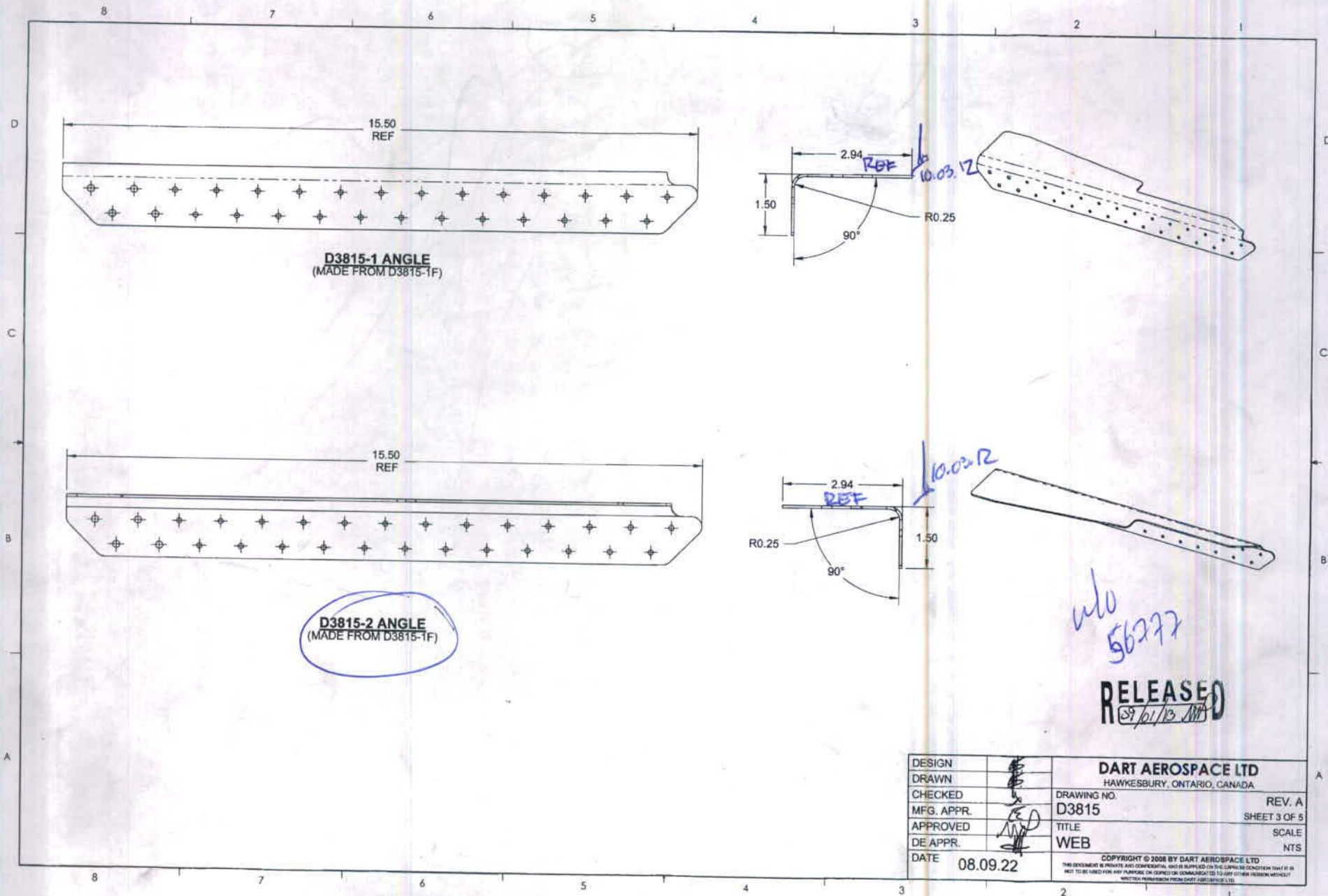
D3815-1F FLAT PATTERN

RELEASED
07/13/13

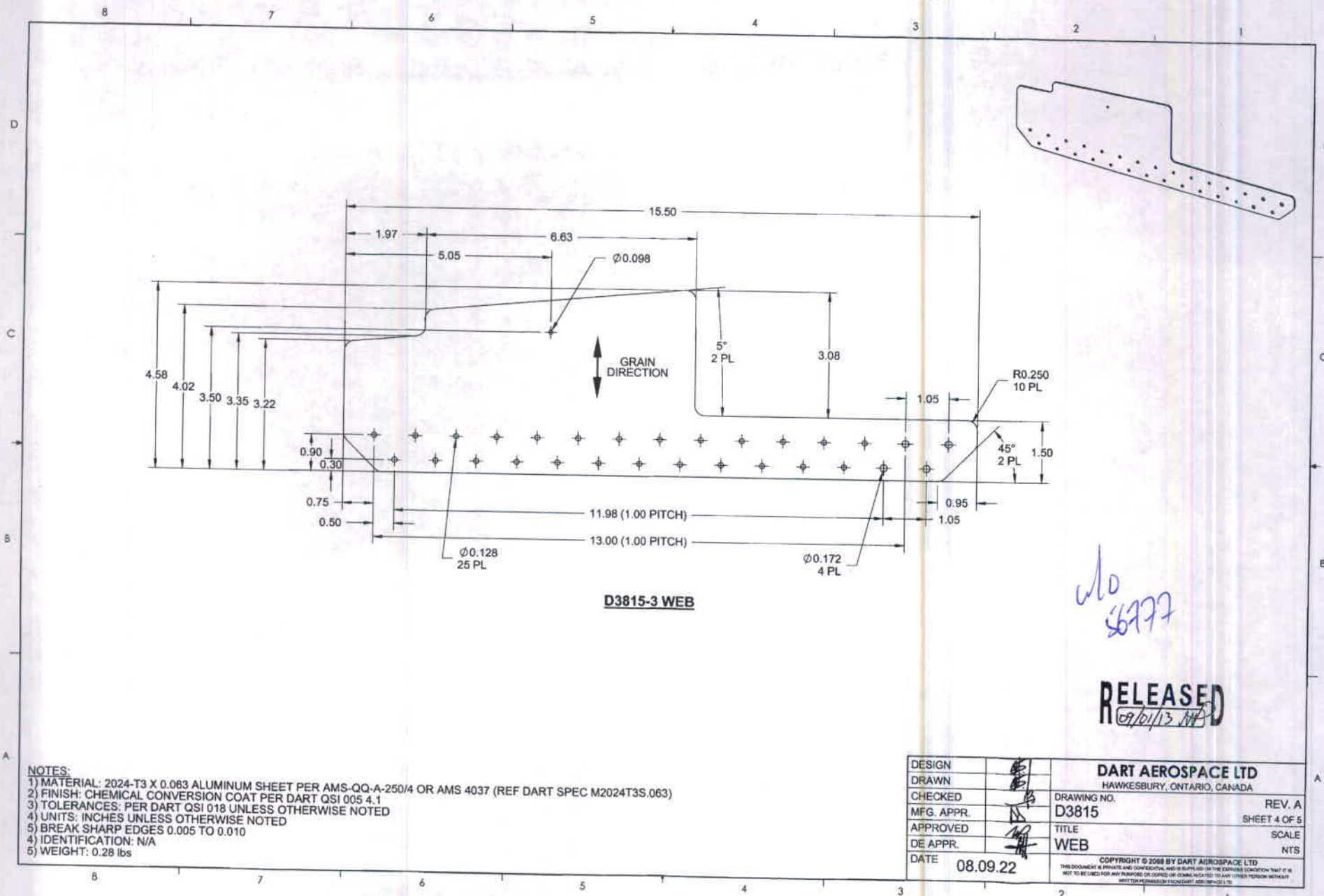
NOTES:

- 1) MATERIAL: 2024-T3 X 0.063 ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010
- 4) IDENTIFICATION: N/A
- 5) WEIGHT: 0.29 lbs

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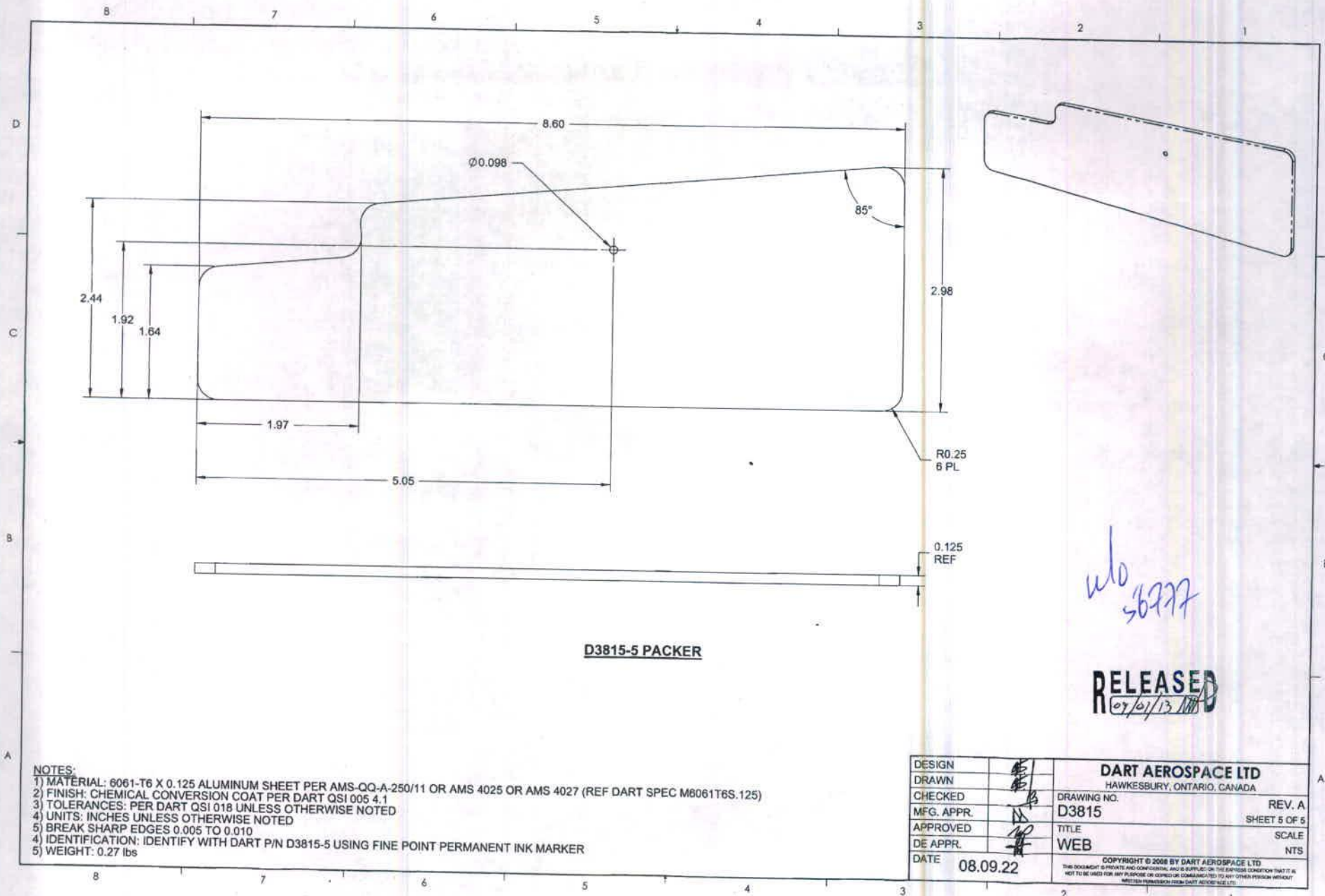
WLO
6777

RELEASED
09/01/13 HRP

NOTES:

- 1) MATERIAL: 2024-T3 X 0.063 ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010
- 4) IDENTIFICATION: N/A
- 5) WEIGHT: 0.28 lbs

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NOTES:

- 1) MATERIAL: 6061-T6 X 0.125 ALUMINUM SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N D3815-5 USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.27 lbs

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